



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

K10111

Job Sheet 187327



Part No: K10111

Job Qty: 1 ea

Part Name: Saddle, Skidtube 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/18

Job Tracking No:

Due Date: 1/4/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG DSI 9583 REV A, K10111 REV C IPP : F 01.11.08 Revised Step 5 and Added Inspection Level 21 SM
IPP REV:G 11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14 AS PER DSI9583 DD VERF:EC

Ship Via:

7330

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/4/19	1/4/19	0.00	0.00	Start Up Stores/Pkg-2		JAN 07 2019
110	Packaging	1 pcs	1/4/19	1/4/19	0.00	0.00	Packaging1-5		JAN 07 2019
120	QC	1 pcs	1/4/19	1/4/19	0.00	0.00	QC4		JAN 08 2019
125	DC	1 pcs	1/4/19	1/4/19	0.00	0.00	DC		JAN 07 2019
130	Packaging	1 pcs	1/4/19	1/4/19	0.00	0.00	Packaging3-2		JAN 08 2019
140	QC21-SA	1 Ea	1/4/19	1/4/19	0.00	0.00	QC21		JAN 07 2019

Part Op 125 - Photocopy bluefile & type labels per PPP K10111 CHG003 FOR D206-642-111 CHG009 FOR D206-642-113
Descriptions: CHG005

130 - Identify and pack for shipping as per PPP K10111 PPP D206-642-111 PPP D206-642-113 Location: _____

PPP rev: _____



Container No: S142187



Part: K10111
Job No: 187327
Serial No/Batch: S142187

Revision:
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/07/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	5038750x7 5133784x1
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	503945
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5019407
AN5-10A	Bolt	4 Ea (4 ea)	90-Start up Operation	5089283x1 5185805
AN5-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	5003927
AN6-44A	Bolt	2 Ea (2 ea)	90-Start up Operation	5123225
D206-651-041	206 A/B Ground Handling Wheel	1 Ea (1 ea)	90-Start up Operation	5127463
D2652-100	Bushing	16 Ea (16 ea)	90-Start up Operation	5136093
D2661-1	Saddle, LH, Fwd, Aft, Out	2 pcs (2 ea)	90-Start up Operation	508989
D2662-1	Saddle, LH Fwd, Aft, In	2 pcs (2 ea)	90-Start up Operation	5128725
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5059587
D2884	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5022936
D2885	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5115843
D3413-1	O-Ring	1 Ea (1 ea)	90-Start up Operation	5165880
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	5132364
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5112434
MS21042L6	Nut	2 Ea (2 ea)	90-Start up Operation	5107756
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation	5124667
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	5107782
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	5092780x8 5129985x17
NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation	5050053
NAS1149D0663J	Washer	4 Ea (4 ea)	90-Start up Operation	5093765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	98	0
	AN4-6A	12	676	0
	AN4C5A	1	59	0
	AN5-10A	4	194	0
	AN5-11A	4	76	0
	AN6-44A	2	124	0
	D206-651-041	1	5	0
	D2652	16	205	0
	D2661-1	2	2	0
	D2662-1	2	5	0
	D2712	10	707	0
	D2884	2	48	0
	D2885	2	32	0
	D3413-1	1	51	0
	MS21042L3	8	3,378	0
	MS21042L4	12	3,104	0
	MS21042L6	2	290	0
	NAS1149C0463R	1	472	0
	NAS1149D0363J	8	1,914	0
	NAS1149D0463J	24	4,221	0
	NAS1149D0563J	8	1,136	0
	NAS1149D0663J	4	770	0

Part Specifications

Specifications could not be found.

Plex 11/30/18 12:45 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>NO</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	